

Split -1

Work Order ID 60372-1



Page 1

July 6, 2010 2:57:58 PM

Item ID: D3784-044

Accept



Setup

Start



Revision ID:

Stop



Item Name: Seat Support Assembly, RH



Cust Item ID:

Start Date: 7/06/10 Start Qty: 4.00

Customer:

Required Date: 7/20/10 Req'd Qty: 4.00



Reference:

Approvals: Process Plan: C2

Date: 10/7/14 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3784	Rev B								

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--



Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging									
-----------	--	--	--	--	--	--	--	--	--

110		0.00							
-----	--	------	--	--	--	--	--	--	--



Small Fab	Small Fab								
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Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

1-assemble as per dwg D3784****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down**** ****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--



QC	Memo	0.00							
----	------	------	--	--	--	--	--	--	--

Quality Control									
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EJS 0/08/18 ①

EJS 0/08/18 ①

1 1008-18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60372

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July 6, 2010 2:57:58 PM

Item ID: D3784-044

Accept



Setup

Start



Stop



Revision ID:

Item Name: Seat Support Assembly, RH

Start Date: 7/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionIdentify as per dwg & Stock Location: C-ASet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Date:

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

E.Sro/08/18 C

10/08/18 J

*MF
10-8-18*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1
2

Work Order ID: 60372



Parent Item: D3784-044



Parent Item Name: Seat Support Assembly, RH

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN525-10R20		Purchased		No		110	Each	110.0000	4	16		EBS 10/08/18	

Screw

Location	Loc Qty	Loc Code
ST325	110	
113524	0	
114227	10	
114348	50	
114354	50	

4

AN960JD10L



NAS1149D0332J Purchased

No

4D M113644(44)

Washer



Location	Loc Qty	Loc Code
ST348	3303	
110985	3303	

4

D3763-041



Manufactured

No

End Fitting Assembly

Location	Loc Qty	Loc Code
ST251	1	
55380	1	
ST251A	4	
57929	4	

8

EBS 10/08/18

B60454

#2
4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

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Work Order ID: 60372



Parent Item: D3784-044



Parent Item Name: Seat Support Assembly, RH

Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 4.00

Required Qty: 4.00

D3763-044



Manufactured No

110

Each

1.0000

1

4



End Fitting Assembly, RH

EBro/08/18

D3770-1



Tube

Manufactured No

110

Each

10.0000

1

4



EBro/08/18

D3770-3



Tube

Manufactured No

110

Each

8.0000

1

4



EBro/08/18

MS21042L3



Nut

Purchased No

110

Each

2,871.000

4

16



EBro/08/18

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

C

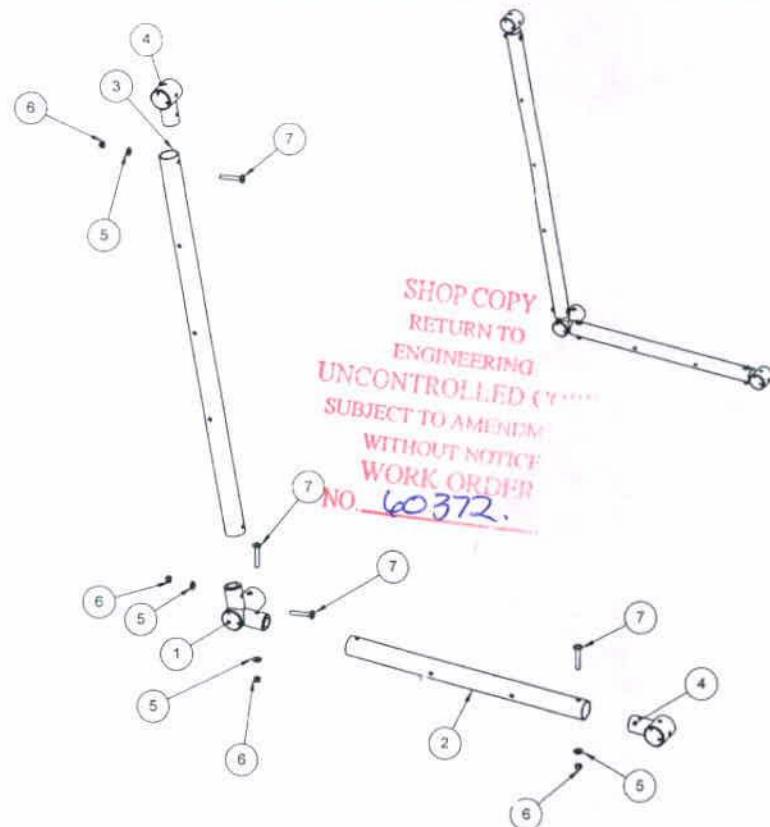
B

B

A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS2104L3	NUT	4
7	AN525-10R20	SCREW	4

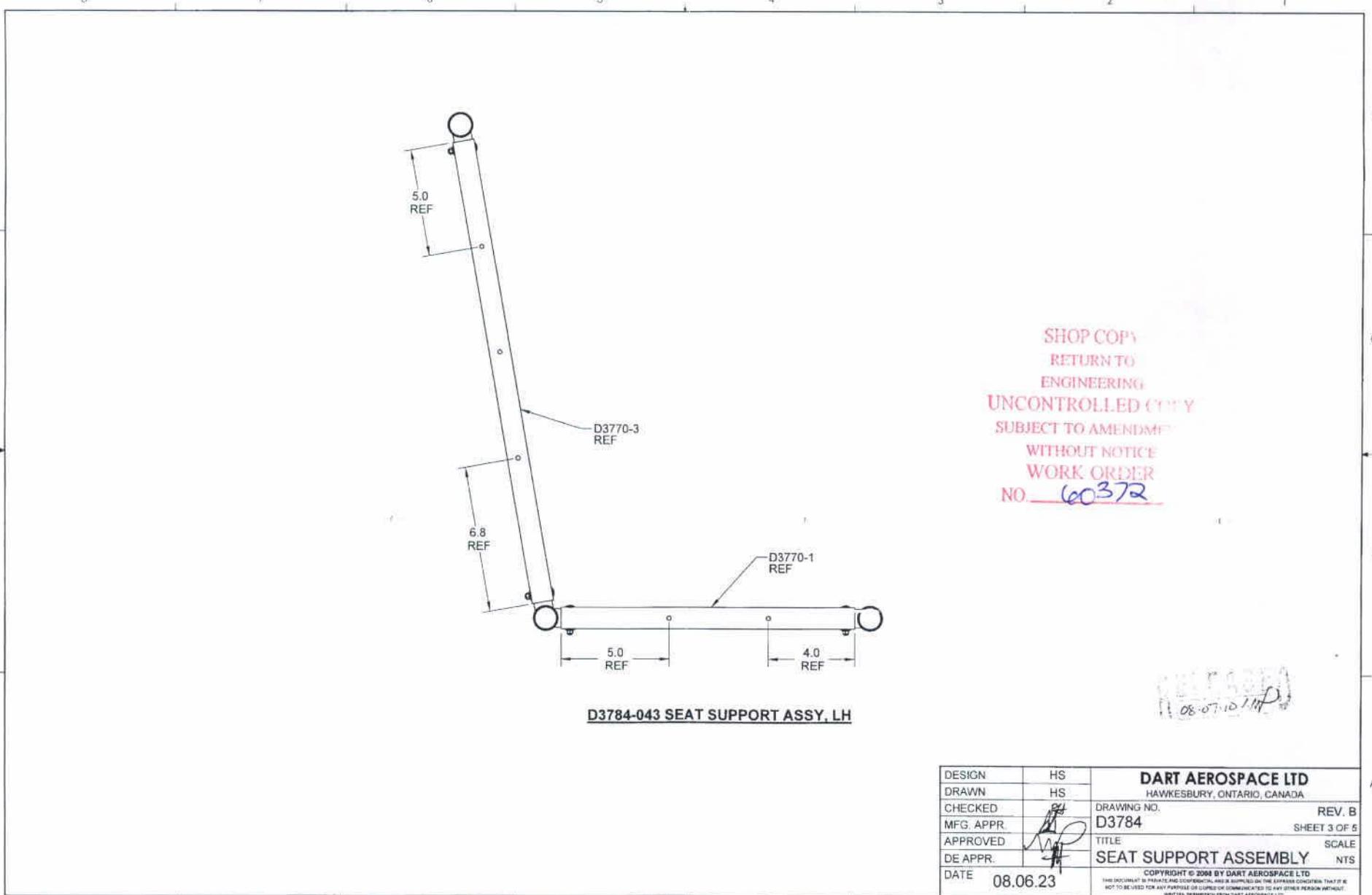
(B)
(B)
(B)D3784-043 SEAT SUPPORT ASSY, LH

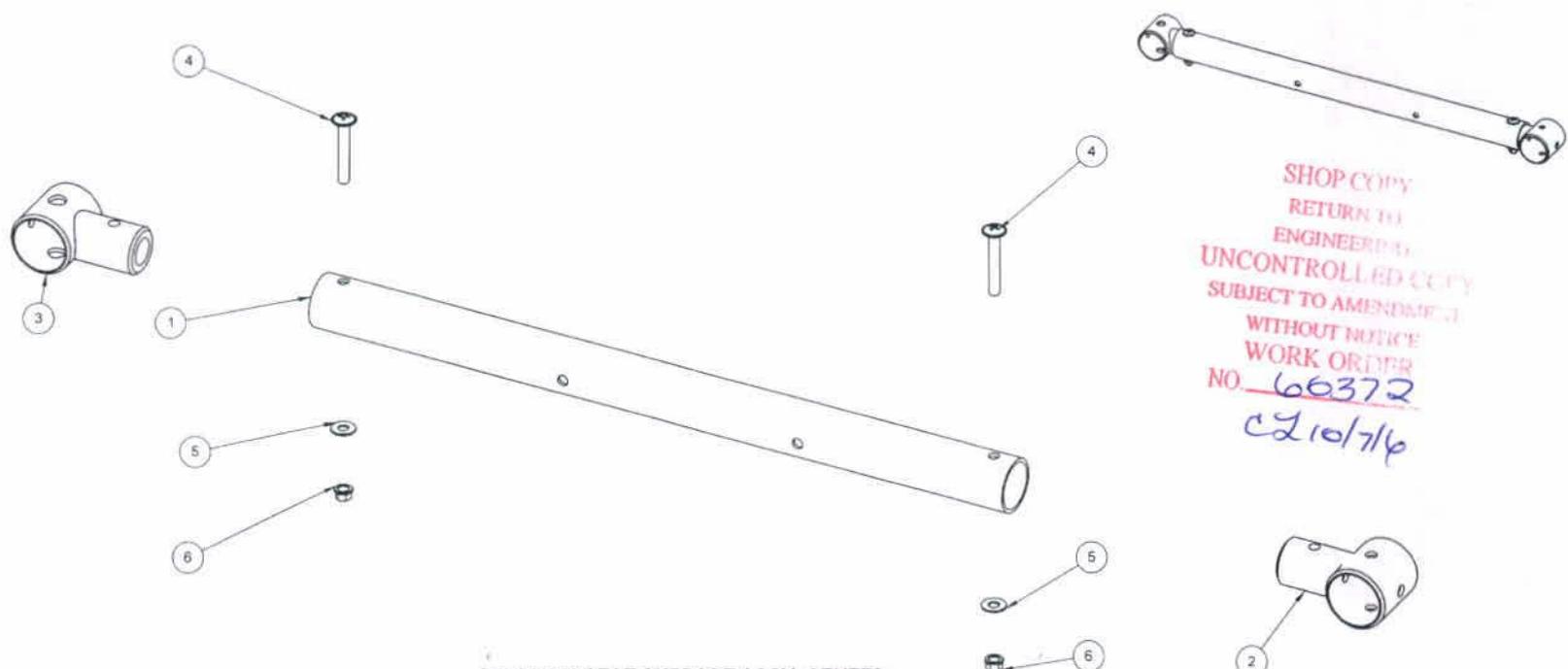
NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.78 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	PA	DRAWING NO.
MFG. APPR.	AM	REV. B
APPROVED		D3784
DE APPR.	#	SHEET 2 OF 5
DATE	08.06.23	TITLE SEAT SUPPORT ASSEMBLY NTS

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D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO. D3784	
CHECKED	M	REV. B TITLE SEAT SUPPORT ASSEMBLY	
MFG. APPR.		SCALE NTS	
APPROVED		DATE 08.06.23	
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NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.31 lbs

8 7 6 5 4 3 2 1

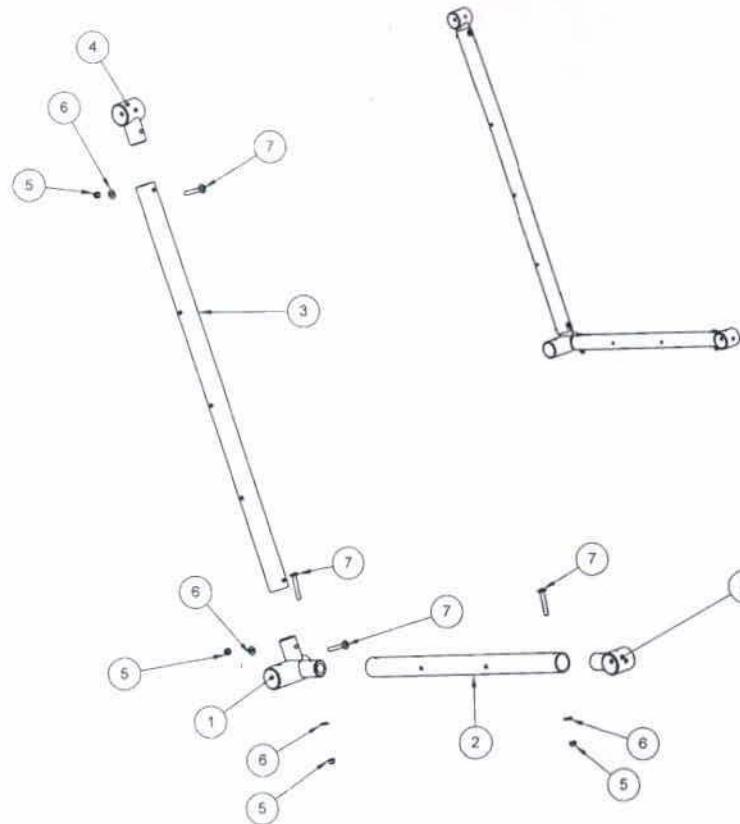
D

C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

D3784-044 SEAT SUPPORT ASSY, RH

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR	<i>[Signature]</i>	D3784	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	SEAT SUPPORT ASSEMBLY	NTS
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60372

